\*109798\*

Page 1

December-02-13	11:46:59 A	<u>M</u>		1 ( ) 2	1190							_
Item ID: Revision ID:	D2367			Accept	*N900	040	100	)*	Setup Star	1.71	S1*	
Item Name:	Handle Knob								Stop	, *N	S2*	
Start Date:	12/02/13	Start Qty: 40.00	*40*	-	Cust Item II	D:						
Required Date:	12/16/13	Req'd Qty: 40.00	*40*		Customer:							
Reference:							_		- 0.			
Approvals:	Process Pla	an: MCS	Date: 13-12-	Tooling:	Da	te:			Run Star	1/7	R1*	
•	QC:		Date:	_ SPC (Y/N):	Da	ite:			Stop	`*N	R2*	
Sequence ID/ Work Center ID	1	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr										
D2367	Rev	' A					<u>.</u> .					
*100 *100* Hardinge Hardinge CNC Lathe	Small	Hardinge CNC LATHE S  Memo  Machine as p	MALL per Folio FA045 and Dwg	0.00 0.00 <del>/</del> D2367 Deburr J	£ 13/12/ fc 2013/12/	04 05		40	_ ф_			-
110 *110* QC Quality Control		QC2- Inspect parts off ma	achine FAI/FAIB	0.00 0.00 F.	* 13/12/	04		40				-
120 *120  CQC Quality Control		QC8- Inspect parts - seco	nd check	OS 00.0	13/12/05	•		40	Ø			-

DQA:		_ Date:											
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	W	ork Order up	odate only	$\neg$	AEROSPACE
Work Orde	)r·				DISPOSITION			AGAIN		PARTMENT			
WOIK OIUE	=1. 			-	Rework	1		Skid-tube Crosstul		1	\A/a+a=  a+[		
Part N	do.				Scrap			Skid-tube Crosstul  Machining Small F	<u> </u>	Bro	Water Jet d. Eng. Coor.	_	Engineering Quality
raiti			-	_	Use-as-is			noforming Finishi	-	-	re/Packaging	ᅱ	Other
NCR N	No				Suspected Unapproved		1110111	Large Fab Composi	-	1 1100	Supplier		Other
Root	<u> </u>		<del> </del>	Desci	ription of work order update		Initial	Action		Sign 9		-	
Cause	Date	Step	Qty	Desci	or non-conformance		nief Eng			Sign & Date	Verification		QC Inspector
Design	Date	Зсер	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		or non-comormance	Cit	ilei Liig	Description		Date	verification	<del>'  </del>	QC Inspector
Doc/Data						1							}
Equip/Tooling												1	
Handling/Pre													
Material													
Operator												١	
Offset/Setup												İ	
Process												-	
Supplier													
Training												ĺ	
Transport													
Unapproved													
						FAI	ULT CAT	TEGORY					
Landi	ng Gear	.,	_		General								
	Bending				Bend		Folio/F	Program		Outside Dim	ensions		Pressure/Forced
	Centre f	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ct [	1	Temperature/Cure
	Crimp/K	(ink/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Unqualified		Part Lost/Mi	ssing	7	Weld
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved			Wrong Stock Pulled
	Crushin	_			Countersink		Misalig	ned/off center		Positioned V	Vrong		
	Heat Tro				Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
		on Strip in	Tube		Drawing		Misread	t					
	Marks/0				Drill Holes		Off-set						
	_	Sequence		<u> </u>	Finish		Out of (	Calibration					
	Wave/T	wist in Tul	oe .	ļ	Fit/Function	1	Out of	Sequence					

***	$\wedge$ 1 T	T 4	
AA/AMIT	f budou i		
VVIII	Order I	., .	114/47

## \*400700\*

December-02-13	3 11:46:59 A	М		1179	1790						1 age 2
Item ID: Revision ID:	D2367		ı	Accept	*N900	<b>0401</b>	იი*	Setup	Start	*N.	31*
Item Name:	Handle Knob								Stop	*N.	<b>32</b> *
Start Date:	12/02/13	<b>Start Qty:</b> 40.00	*40*		Cust Item I	D:					
Required Date: Reference:	12/16/13	Req'd Qty: 40.00	*40*		Customer:						
Approvals:	Process Pla	n:	Date:	Tooling:	Da	ate:	~ <del>~~</del>	Run	Start	*NF	₹1*
	QC:		Date:	SPC (Y/N):	Da	ate:	<u></u>		Stop	*NF	₹2*
Sequence ID/ Work Center II	D	Operation Description	6:7000	Set Up/ Run Hours	Tool ID	Tool# P.	lan Acce ode Qty	ept Re Qt			Insp. Stamp
*130 *130* Packaging		Identify as per dwg & Sto	ck Location: 57007	0.00			_4	2x_	DAS 28 /3	3-12-	5
Packaging		Memo							<del>5-</del> 69		
140		QC21- Final Inspection -	Work Order Release	0.00					13/1	- la	M
*140* QC Quality Control		Memo		0.00							
Quanty Control							-			4	
							(	)[13	-12	,	
							1				

DQA:			Date:										10	
OA Classide			Data			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE	14/	1-01	-d-4		AEROSPACE
QA Closed:			Date:		1					VV	ork Order up	date only		
Work Orde	er:					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		
	-				_	Rework	1		Skid-tube Crosstube	e	]	Water Jet	7 1	Engineering
Part i	No.					Scrap			Machining Small Fal	-	Pro	d. Eng. Coor.	┤ `	Quality
	-					Use-as-is	1		noforming Finishin	g	1	re/Packaging	7	Other
NCR f	No					Suspected Unapproved			Large Fab Composite	e	]	Supplier		
			i						<u> </u>					
Root		<b>.</b> .			Desci	ription of work order update		Initial	Action		Sign &			
Cause	$\dashv$	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	_	QC Inspector
Design	Н													
Doc/Data	$\vdash$													
Equip/Tooling	H													
Handling/Pre	H										'			
Material	Н												1	
Operator	Н													
Offset/Setup	Н						ŀ							
Process	Н													
Supplier	H													
Training Transport	Н												İ	
Unapproved	H												1	
опарриотеа			1				FΔI	UIT CA	TEGORY		l		L	
Landi	ng G	ear				General		OLI CA						
		Bending				Bend		Folio/F	Program	Г	Outside Dim	ensions [	Pr	essure/Forced
	$\vdash$	. •	ot Concen	ntric		BOM/Route	<b>-</b>	Grain		-	Over/Under	<b>-</b>	_	et-up
	$\vdash$	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred		_	mperature/Cure
	$\prod_{i}$	Crimp/Kir	nk/Ripple,	/Wave		Burrs		1	ion Incomplete/Unqualified		Part Lost/Mi	<b>-</b>	-	eld
	$\vdash$	Cuffs	, , ,			Contamination		1	tions Incomplete/Unclear		Part Moved		— 1	rong Stock Pulled
	П	Crushing				Countersink	_	4	gned/off center		Positioned V	∟ Vrong		
	-	Heat Trea	ıt			Cut Too Short		Mislabe			Power Loss/		Tot	her
	$\square$	Inspectio	n Strip in	Tube		Drawing		Misread			٠,٠	ت		
	$\Box$	Marks/Ch	atter			Drill Holes		Off-set						
	$\square$	Turning S	equence			Finish		4	Calibration					
	Γ,	Wave/Tw	ist in Tub	e		Fit/Function		4	Sequence					

Picklist Print

December-02-13 11:47:02 AM

Work Order ID: 109798

\*109798\*

Parent Item:

D2367

\*D2367\*

Parent Item Name: Handle Knob

Start Date: 12/02/13

Required Date: 12/16/13

Page

**Start Qty: 40.00** 

Required Qty: 40.00

Comments:

IPP, A02.10.29New issueKJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500		Purchased	No		100	f	5.8000	0.045	2			
		<b>10</b> +						44				

EXMOFI RINR1 2500\*
DELRIN ROUND BAR 1.25"

<b>Location</b>	Loc Qty	Loc Code		
MAT039	5.8			
m126596	5.8		 JFC	2013-12-05

DQA:		Date	:		. WORK ORDER NON	c	ONEOI	DAANCE / III	DDATE			`DART
QA Closed:		Date	:		WORK ORDER NON-		JINFUI	NIVIAINCE / OF		/ork Order up	odate only	AEROSPACE
Work Orde	· ·				DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
WOIK OTUE	=1. 				Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	۱a.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is			noforming	Finishing		re/Packaging	Other
NCR N	No				Suspected Unapproved			Large Fab	Composite		Supplier	
Root				Desc	ription of work order update		I Initial	Act	ion	Sign &		
Cause	Dat	e Step	Qty		or non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre			İ			ļ						
Material												
Operator												
Offset/Setup	_											
Process	$\vdash\vdash$							·				
Supplier	$\vdash$											
Training	$\vdash$					1						
Transport Unapproved	H											
Ollapproved		L	_1	i		FΔ	LILT CAT	TEGORY			L	<u> </u>
Landi	ng Gear				General	17	OLI CA	1200111				
	Bend	ng			Bend		]Folio/F	rogram	Г	Outside Dim	ensions	Pressure/Forced
	$\vdash$	e Not Conce	entric		BOM/Route		Grain		<u> </u>	Over/Under		Set-up
	Crack				Broken/Damage/Defect		Hardwa	ire	<u> </u>	Part Incorre	<b>├</b> ─	Temperature/Cure
	$\vdash$	/Kink/Ripp	e/Wave		Burrs	$\vdash$	1	ion Incomplete/Ur	ngualified	Part Lost/Mi	<u> </u>	Weld
	Cuffs				Contamination		1 '	ions Incomplete/U	· —	Part Moved		Wrong Stock Pulled
	Crush	ing			Countersink		₹	ned/off center		Positioned V	 Vrong	<b>_</b>
	Heat	Treat			Cut Too Short		Mislabe			Power Loss/		Other
	Inspe	ction Strip i	n Tube		Drawing		Misread	d	_		• • • • • • • • • • • • • • • • • • •	
	Mark	s/Chatter			Drill Holes		Off-set					
	Turni	ng Sequenc	e		Finish		Out of	Calibration				
	Wave	/Twist in Tu	ihe		Fit/Function		Out of	Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	109798
Description: Handle Knob	Part Number:	D2367
Inspection Dwg: D2367 Rev: A		Page 1 of 1

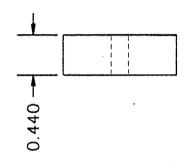
	FIRS	T ARTICLE IN	ISPECTIO	ON CHE	CKLIST		
		X First Artic	ele	Proto	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
1.250	+/-0.010	1,251	7		FK-04	Vern	
Ø0.193	+0.005/-0.000	5910	7		(5	4,	
0.440	+/-0.010	. 440			1.	h	
_							
							·
							•
						-	
				-			
				<del></del>			
				1		_	
					-		
Measured by:	F.K.	Audited by:	70		Prototype Ap	proval:	N/A
Date:	13/12/04	Date:	13/12/0	<u> </u>		Date:	N/A
			<del>-</del>				<del></del>

Rev	Date	Change	Revised by	Approved
Α	06.04.10	New Issue	KJ/JLM	
				<del></del>



DESIGN B WILLIAMS	ORAWN BY K HÂND	DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT,		
CHECKED	APPROVED	DRAWING NO.		REV. A
Pow	$\mathcal{A}$	D2367	SHEET	1 OF 1
DATE	,	TITLE	<del>//-//////////////////////////////////</del>	SCALE
95:02:22		HANDLE KNOB		1:1

## RELEASE 19606 10 BW



107758 MLJ 13-12-02

BREAK ALL EDGES .015 MAX MATERIAL: BLACK DELRIN

